

Date: Monday, 8/21/2006 2:11:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28257
 Estimate Number : 10330
 P.O. Number : N/A
 This Issue : 8/21/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 27485
 Drawing Name : WEARSHOE
 Part Number : D2746
 Drawing Number : D2746 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 8/28/2006 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: B 02-10-24 Re-format KJ
 Est Rev: E 06-03-21 as Per Rev C JLM
 Est Rev: F 06-06-12 Now On Waterjet JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

SAD 06:09:03

20

2.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.4263 sf(s)/Unit Total: 8.5260 sf(s)

1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: M101463

SAD 06:09:03

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:09:03

20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 06:09:03 20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 06:09:14

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 28257

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB 06/09/20

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-26

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

JK

Q.M 06-09-27

(20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 27 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FPD

FC 06 09 27 20

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/27 (20)

Job Completion



U 06 09 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

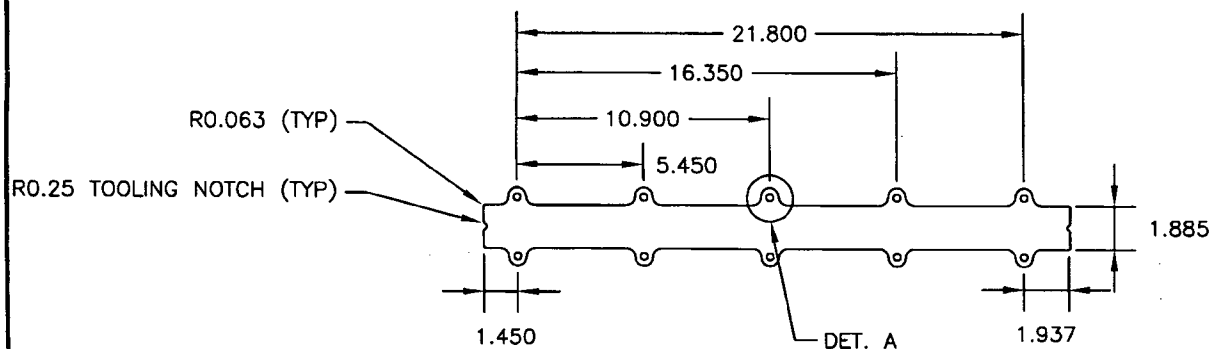
QA: N/C Closed: _____ Date: _____

DART

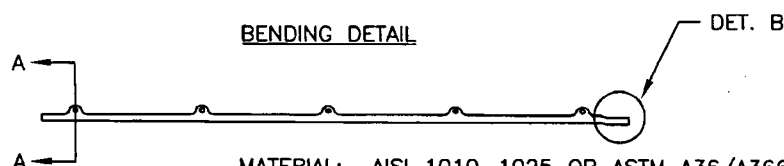
RELEASED
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PJ1	PJ1	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2746
DATE	TITLE	REV. C
06.01.12	WEARSHOE	SHEET 1 OF 1
		SCALE
		1:8
A	98.04.16	NEW ISSUE
B	98.08.18	RE-DESIGN
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT

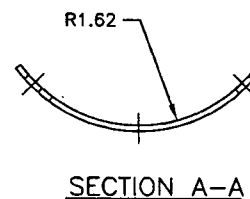
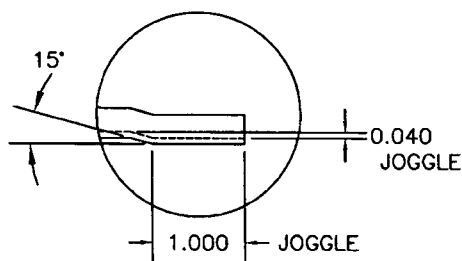
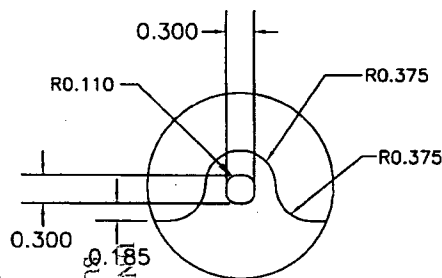
FLAT PATTERN



BENDING DETAIL



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL B

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL,
20 GAUGE (0.040 THICK)

- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

UNCONTROLLED COPY
ENGINEERING
SHOPEX
RETURN TO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2825101